

Work Order ID 53947

November 23, 2009 3:01:07 PM



Page 1

Item ID: D3926-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wedge

Start Date: 23/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: B7

Date: 09-11-23

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3926

Rev A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3926

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

09-11-26

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

09-11-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53947

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Page 2

Item ID: D3926-1

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Setup Start



Revision ID: A

Stop



Item Name: Wedge

Start Date: 23/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan,
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



⇒ Serial 30

QC

Memo

0.00

Quality Control

(12)

f

130

0.00



Small Fab

Memo

0.00

SB 09/12/01

Small Fab

1- Deburr if necessary

h

140

QC5- Inspect part completeness to step on W/O

0.00



⇒ Serial 02

QC

Memo

0.00

Quality Control

(12)

f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53947

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Page 3

Item ID: D3926-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Wedge

Start Date: 23/11/2009 Start Qty: 6.00



Cust Item ID:

Required Date: 02/12/2009 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

9/12/2 58 (120)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/03 98
PL 09-12-3
(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 3:01:13 PM

Page 1

Work Order ID: 53947

Parent Item: D3926-1RevA

Parent Item Name: Wedge



Comments:

Start Date: 23/11/2009

Required Date: 02/12/2009

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			100	sf	387.8629	2.2794	4.5588		
												

B 9-11-26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	345.7752	
112186	126.5752	
112514	11.2	
113166	208	
Main Warehouse		
ST	42.0877	
111354	42.0877	

112186

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	53947
Description: Wedge		Part Number:	D3926-1
Inspection Dwg: D3926		Rev: A	Page 1 of 1

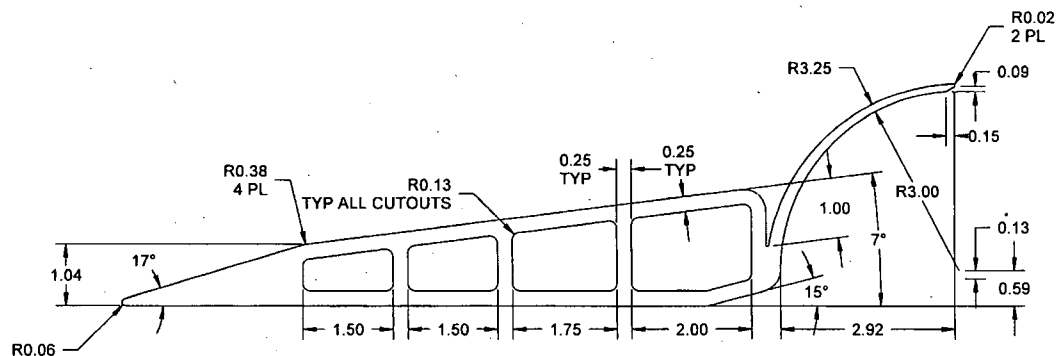
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.04	+/-0.030	1.044	✓			
1.50	+/-0.030	1.511	✓			
1.50	+/-0.030	1.503	✓			
1.75	+/-0.030	1.749	✓			
2.00	+/-0.030	1.995	✓			
2.92	+/-0.030	2.92	✓			
1.00	+/-0.030	.987	✓			
0.25	+/-0.030	.253	✓			
0.25	+/-0.030	.265	✓			
3.71	+/-0.030	3.720	✓			
1.00	+/-0.030	1.004	✓			
14.01	+/-0.030	14.00	✓			

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	9-11-26	Date:	09/11/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.17	New Issue	KJ	[Signature]

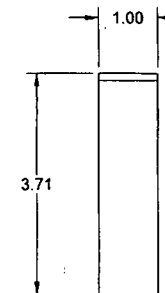


D3926-1 WEDGE

NOTES:

- 1) MATERIAL: 1.00" UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMB10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3926-1" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

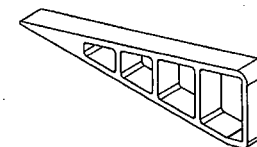
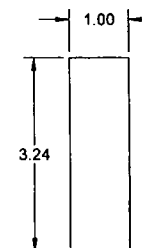
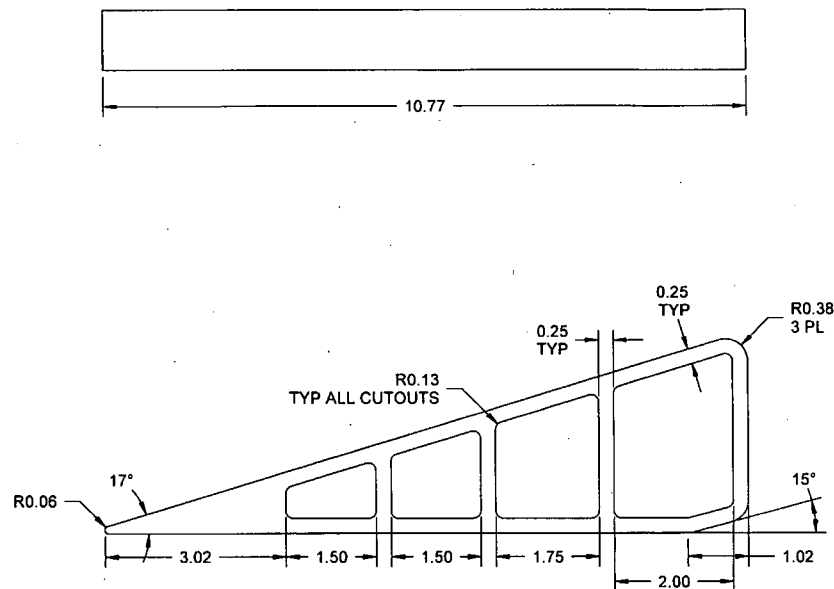
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53947
PH 09-11-23



RELEASED

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE		09.07.23
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.23		

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D3926	REV. A SHEET 1 OF 2
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SHOW ONLY
REF
ENGINE
UNCONTROLLED
SUBJECT TO
WITH
WORK
NO. 53947

D3926-3 WEDGE

NOTES:

- 1) MATERIAL: 1.00" UHMW BLACK TIVAR 1000 VIRGIN MATERIAL
REF DART SPEC MUHMWB10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3926-3" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.25 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. A
MFG. APPR.		D3926	SHEET 2 OF 2
APPROVED		TITLE	SCALE
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9/6/17